



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE703A95-0520-01-1
Job Sheet 189284



Part No: RBE703A95-0520-01-1

Job Qty: 6 pcs

Part Name: Quill



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A95-0520-01-1 REV:4 IPP REV:A 18.01.17 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	SL-154 - 1	6 pcs	2/8/19	2/8/19	0.00	1.00	SL-154 - 1		19/03/03
150	QC 2	6 pcs	2/8/19	2/8/19	0.00	0.50	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		19/03/03
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S158394



Part: RBE703A95 - 0520 - 01 - 1

Job No: 189284

Serial No/Batch: S158394

Revision: J

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/29/19

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160 QC 8

6 pcs

2/8/19

0.00 0.00

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 38

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

B.e 19-03-23

190 Outsource - 4 - Anodize 6 pcs

2/8/19

GRO002-VC

10

03/25/2019 PL

200 Packaging 2-1 - Receive - B4B 6 pcs

2/8/19

0.00 0.00

Packaging 2 - 1 - B4B

Packaging 2 - 2 - B4B

Packaging 2 - 3 - B4B

Packaging 2 - 5 - B4B

Packaging 2 - 4 - B4B

Packaging 2 - 6 - B4B

Packaging 2 - 7 - B4B

Packaging 2 - 8 - B4B

Packaging 2 - 9 - B4B

Packaging 2 - 10 - B4B

Packaging 2 - 11 - B4B

Packaging 2 - 12 - B4B

Packaging 2 - 13 - B4B

Packaging 2 - 14 - B4B

Packaging 2 - 15 - B4B

Packaging 2 - 16 - B4B

Packaging 2 - 17 - B4B

Packaging 2 - 18 - B4B

Packaging 2 - 19 - B4B

Packaging 2 - 20 - B4B

Packaging 2 - 21 - B4B

Packaging 2 - 22 - B4B

Packaging 2 - 23 - B4B

Packaging 2 - 24 - B4B

Packaging 2 - 25 - B4B

Packaging 2 - 26 - B4B

Packaging 2 - 27 - B4B

Packaging 2 - 28 - B4B

Packaging 2 - 29 - B4B

Packaging 2 - 30 - B4B

Packaging 2 - 31 - B4B

Packaging 2 - 32 - B4B

Packaging 2 - 33 - B4B

Packaging 2 - 34 - B4B

Packaging 2 - 35 - B4B

Packaging 2 - 36 - B4B

MAR 29 2019

210 QC 6

6 pcs

2/8/19

0.00 0.00

QC 6 - 38

					QC 6 - 42	
					QC 6 - 9	DAS
					QC 6 - 68	MAR 29 2019 68
					QC 6 - 61	9-89
211	Small Fab - 2 - B4B	6 pcs	2/8/19	0.00 0.60	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
212	QC 5	6 pcs	2/8/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
220	Packaging 3-1 - Stock - B4B	6 pcs	2/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	N/C
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

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230 QC 21 - SA 6 pcs 2/8/19 0.00 0.00	CHG N/A TO RBET03A95-0520-01-17	Packaging 3 - 31 - B4B	
		Packaging 3 - 32 - B4B	
		Packaging 3 - 33 - B4B	
		Packaging 3 - 34 - B4B	
		Packaging 3 - 35 - B4B	
		Packaging 3 - 36 - B4B	
	in computer ECU 19-561	QC 21 - SA - 21	21
		QC 21 - SA - 70	8-38 APR 03 2019

Part Op 140 - SL-154 (MORI SL-154 LATHE) 1-1-Machine as per folio FB790 FOLIO REV: _____ DWG REV: _____
 Descriptions: 2-Deburr 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

150 - (QC2- Inspect parts off machine FAI/FAIB)

160 - (QC8- Inspect parts - second check)

190 - Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required

200 - (Receive & Inspect for Damage & Mat'l Certs) Receive

210 - (QC6- All purchased or subcontracted products)

211 - (Small Fab) 1-Cut -11 to length as per DWG. 2-Cut -15 as required 3-Assemble quill (-1) as per DWG. 4-Pack as per DWG.

212 - (QC5- Inspect part completeness to step on W/O)

220 - (Identify as per dwg & Stock Location: _____) Identify and Stock

230 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.000	Round Bar 1.00"	1.3140 ft (.219 ea)	140-SL-154 - 1	5/127980
2044T47	Tube Ø1.09	6 1.6800 ft (.28 ea)	211-Small Fab - 2 - B4B	5/137333
2044T67	Cap Ø1.09	44 2 Ea (2 ea)	211-Small Fab - 2 - B4B	5/152045 32X 5/137367 12X
91585A030	Dowel Pin	60 8 Ea (3 ea)	211-Small Fab - 2 - B4B	5/161569
9263K519	O-ring	22 6 Ea (1 ea)	211-Small Fab - 2 - B4B	20X 5/151942 2X 5/161584
PAD210	Feam Ø1 X1	4800 sf (.08 ea)	211-Small Fab - 2 - B4B	5/021250

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
140-SL-154 - 1	M6061T6R1.000	1	45	0
211-Small Fab - 2 - B4B	2044T47	2	29	0
	2044T67	12	113	0
	91585A030	18	47	0
	9263K519	6	7	0
	PAD210	0	12	0

Part Specifications

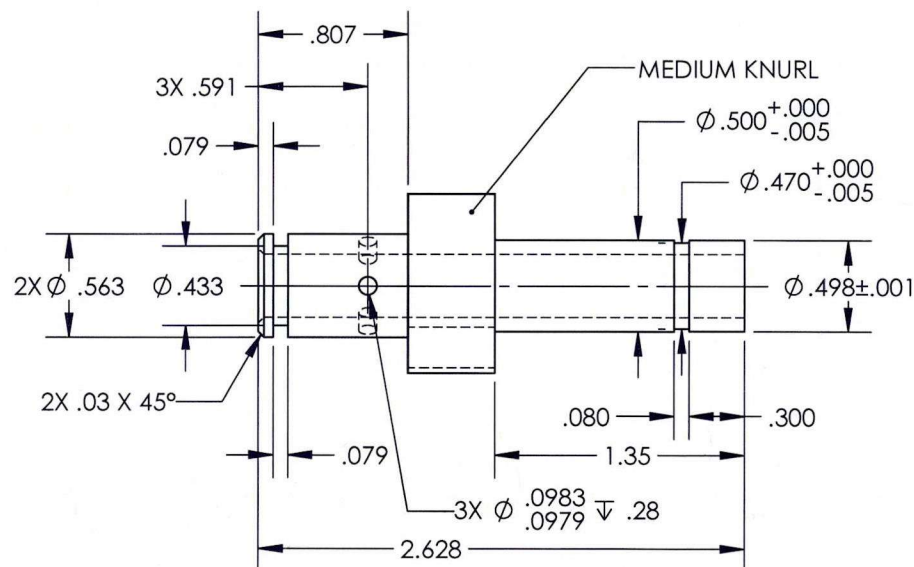
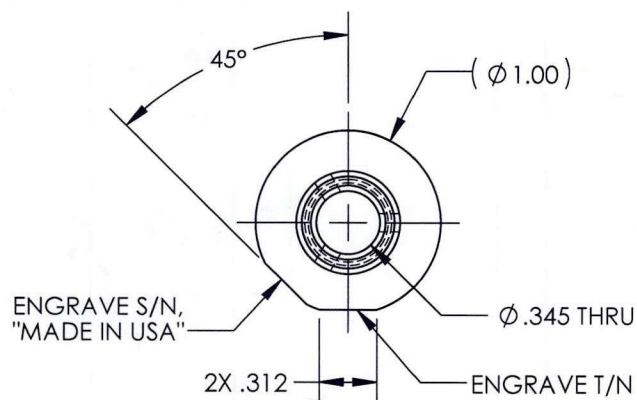
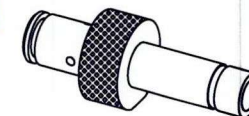
Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SECOND FLAT TO ENGRAVE S/N & "MADE IN USA", ADDED NOTE TO DETAIL	5/22/2009	RJC	
2		CH'D P/N -1 MATERIAL FROM STRESS PROOF & FINISH SPEC TO RED ANODIZE PER WP & DW, ADDED MIL SPEC PER WP.	10/29/2009	RJC	RW
3		MODIFIED -1 TO WORK WITH COUPLING	7/31/2012	JAG	
4	14-0209	-1 REMOVED .059 LIP FROM INPUT SIDE OF QUILL. CH'D DIM WAS Ø1.00 IS (Ø1.00). DELETED DIM 3X .591. ADDED DIM 3X .216.	11/5/2014	DPD	JAG

SEE ATTACHED DEVIATION



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189284 19-01-22

(-1)

QUILL

DART AEROSPACE	
TITLE ENGINE & HYDRAULIC DRAIN TUBE	
DWG NO. RBE703A95-0520-01-1	REV 4
MAT'L 6061	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	RED ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	EUROCOPTER AS350A
SCALE 1:1	DATE 11/10/2008 SHEET 2 OF 2



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www.dartaerospace.com

Container No: S158394



Part: RBE703A95-0520-01-1

Job No: 189284

Serial No/Batch: S158394

Revision: J

Inspector:

Exp Date:

Instructions:

Date: 03/03/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042980



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042980

PO Date: 3/25/19

Due Date: 4/1/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189581	RBW109-3101-86-101-1	Ring, 1-3/4 x 1-3/4 x 3-7/8 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/1/19	12 pcs	0 pcs	12 pcs	\$10.00/pcs	\$120.00
							12 x	MAR 29 2019			
2	189284	RBE703A95-0520-01-1	Quill Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	4/1/19	22 pcs	0 pcs	22 pcs	\$5.46/pcs	\$120.12
							22 x	MAR 29 2019			
Grand Total:											\$240.12



Dart Aerospace Ltd.
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PURCHASE ORDER PO042980



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, likely belonging to Patrick Lussier, is written over the bottom right portion of the Order Notes section.

Plex 3/26/19 1:31 PM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance



0 1 7 9 6 9 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017969- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Mar-2019		Shankar Anand		042980				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW109-3101-86-101-1 Rev.	RBW109-3101-86-101-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	12	12	0	0	0
2	RBE703A95-0520-01-1 Rev.	RBE703A95-0520-01-1 01 -ANO-RED [ANODIZE RED] ANODIZE COLOR RED PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	22	22	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.